

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014660**Date Inspected:** 13-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONI INSPECTION

OBG SEGMENT 8BW

ABF Request No: 06122010-2

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between edge panel and deck panel (cross beam side) of OBG segment 8BW. Inspection was carried out on repair areas. The weld designations are as follows.

CA050-002, 006 (OBG 8BW, E.P to D.P - Cross beam side)

ULTRASONI INSPECTION

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

### OBG SEGMENT 8CW

ABF Request No: 06122010-2

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between edge panel and deck panel (cross beam side) of OBG segment 8CW. Inspection was carried out on repair areas. The weld designations are as follows.

SEG047\*-043 (OBG 8CW, E.P to D.P - Cross beam side)

### ULTRASONIC INSPECTION

### OBG SEGMENT 9AE-9BE

ABF Request No: 06122010-2

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between bottom panel and side panel (Bike path side) of OBG segment 9AE and 9BE. Inspection was carried out on repair areas. The weld designations are as follows.

SEG050A-012, SEG052A-044 (OBG 9AE-9BE, S.P to B.P, Bike path side)

### ULTRASONIC INSPECTION

### OBG SEGMENT 7BW

ZPMC NWIT No: 005967

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 7BW.

FB027-PP52-128; FB023-PP52-128; FB039-PP50-128

### MAGNETIC PARTICLE INSPECTION

### OBG SEGMENT 8BW

ABF Request No: 06122010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between deck panel and edge panel of OBG segment 8BW (Cross beam side). Inspection was carried out on repair areas. Weld identification number were.

CA050-002, 006 (OBG 8BW, E.P to D.P - Cross beam side)

No relevant indications were observed.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### MAGNETIC PARTICLE INSPECTION

#### OBG SEGMENT 8CW

ABF Request No: 06122010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between deck panel and edge panel of OBG segment 8CW (Cross beam side). Inspection was carried out on repair areas. Weld identification number were.

SEG047\*-043 (OBG 8CW, E.P to D.P - Cross beam side)

No relevant indications were observed.

### MAGNETIC PARTICLE INSPECTION

#### OBG SEGMENT 9AE-9BE

ABF Request No: 06122010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between bottom panel and side panel of OBG segment 8CW (Bike path side). Inspection was carried out on repair areas. Weld identification number were.

SEG050A-012, SEG052A-044 (OBG 9AE-9BE, S.P to B.P, Bike path side)

No relevant indications were observed.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

#### **Summary of Conversations:**

Only general conversation was held between QA and QC

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Utekar,Shrikant
<b>Reviewed By:</b>	Dawson,Paul

Quality Assurance Inspector

QA Reviewer